

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021930**Date Inspected:** 16-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019C

Weld No: 046~049

Welder: 055564

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

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PCMK: SEG-3019N
Weld No: 115
Welder: 054013
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG-3019N
Weld No: 119
Welder: 044779
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG-3009M
Weld No: 093
WR: 20248
Welder: 0215553
WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3019P
Weld No: 162
WR: 20247
Welder: 216086
WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3019Z
Weld No: 006
WR: 20361
Welder: 043661
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: W5-SB31A-001
Weld No: 063~074, 079, and 080
Welder: 053753
WPS-B-P-2113

PCMK: W5-SB30A-001
Weld No: 096 and 100~105
Welder: 201861
WPS-B-P-2113

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PCMK: W5-SB30-001

Weld No: 001~012

Welder: 201905

WPS-B-P-2113

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: W5-SB20A-001

Weld No: 019, 050, and 081

Welder: 053742

WPS-2131-ESAB

PCMK: E2-SB23-002

Weld No: 126~131

Welder: 048625

WPS-2132-ESAB

PCMK: W2-SB18-001

Weld No: 126~131

Welder: 201889

WPS-2132-ESAB

PCMK: E5-SB32-002

Weld No: 126~131

Welder: 206296

WPS-2132-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Heat Straightening (HSR) process.

ZPMC QC is identified as Ma Qian Li.

Heat Straightening variables recorded by QC appeared to comply with the approved Heat Straightening Procedure Specification (HSR). Listed below are the locations that were identified by this QA inspector.

PCMK: SA-6029 and SA-6030

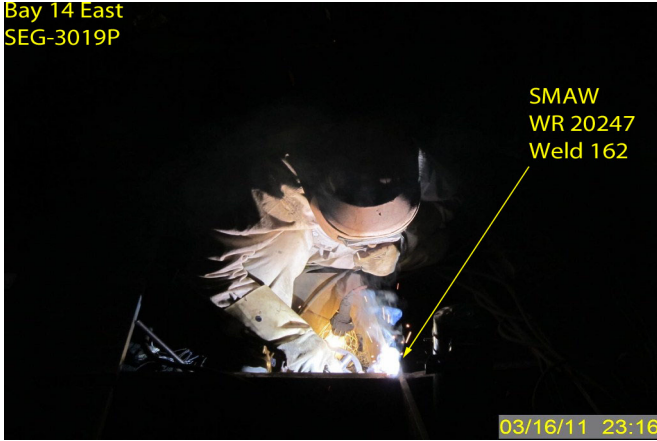
HSR1 (B)-10182

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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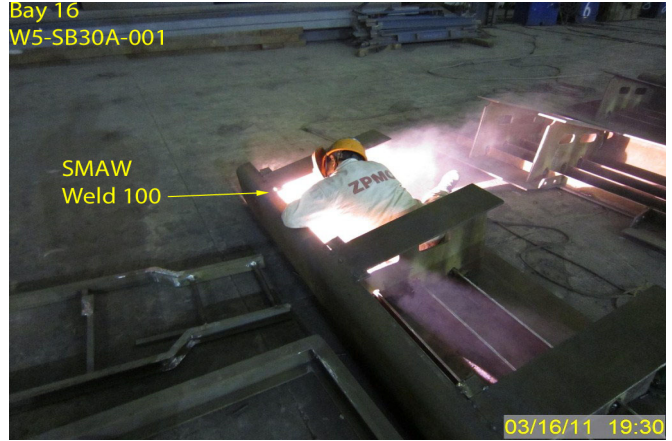
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Bay 14 East
SEG-3019P



SMAW
WR 20247
Weld 162

Bay 16
W5-SB30A-001



SMAW
Weld 100

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Rice,Brett

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer